Wednesday, 09/07/2008 8:04:48 AM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 40390

Estimate Number

: 10823

P.O. Number

This Issue

: 09/07/2008

: NC

: //

Type

S.O. No. :

: MACHINED PARTS

: 40084 Previous Run

Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

: Est. D 05.11.02

Est Rev:E

Removed 303SS

KJ/EC JLM

Drawing Name

: SPACER BUSHING

Part Number

: D23271 : D2327 REV D

Drawing Number Project Number

: N/A

Drawing Revision

: D

Material **Due Date**

: 16/07/2008

Qty:

50 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

M304R0375

9.2978 f(s)

Comment: Qty.: 0.1860 f(s)/Unit Total: Inventory

Material: AISI 304 Round Bar Ø0.375"

(M304R0.375)

HARDINGE

Description:

304 SS ROUND BAR

Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

2.0

QC8

SECOND CHECK





Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 26

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:				Date:	
NCR:			WORK ORDE	R NON-CONFORMA					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
			one Eng	Office Eng	Date				
									;

Date: User: Wednesday, 09/07/2008 8:04:48 AM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 40390

Part Number: D23271

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/219

Job Completion



U 08.07.21

Dart Ae	rospace	Ltd							
W/O:			WC	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:		_ Date: _	
				*	QA: N	C Closed:		_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	n B	Verificat	tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	1	Chief Eng	Approval QC Inspector
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NCK:												
		Description of NC		Corrective Action Section B			Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector				
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DART AEROSPACE LTD	Work Order:	40390
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327 Rev: D		Page 1 of 1

	FIR	ST ARTICLE I					
		X First Art	icle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
Ø0.375	+/-0.010	\$,376"					=
Ø0.257	+0.005/-0.000	Ø, 259"		/			
2.000	+/-0.010	2,002"					
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easured by:	T.F.	Audited by:	Sil		Prototype App	oroval:	N/A
Date:	8/07/17	Date:	08/07/1	8		Date:	N/A
ev Date	Change		//		Rev	rised by	Approve

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	06.11.24	Dwg Revision revised	KJ/JLM	
С	08.02.01	Tolerance revised for Ø0.375	KJ/EC/DD	7

Dart Ae	rospace	Ltd	2-						
W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #·	Fault Cate	gory: NC	P. Ves	No DO	۸.	Date:	
· urt rto	•	ΙΑΙΝ#.	raun cate	gory No				_ Date: _ _ Date: _	
NCR:		1	WORK ORDI	ER NON-CONFORMANC	E (NCR	:)			
		Description of NC		Corrective Action Section B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
		4							
		1.77							

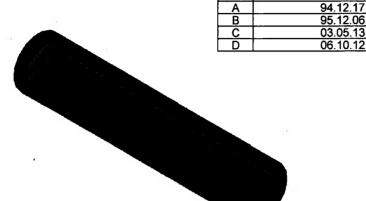


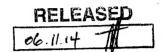
DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	D2327		REV. D SHEET 1 OF 1			
DATE 06 .1	10.12	TITLE SPACER BUSHING		SCALE 2:1			

NEW ISSUE

LENGTH CHANGE 303 SS SPEC ADDED

REMOVE 303 SS MATERIAL



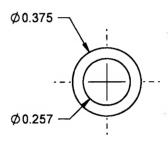


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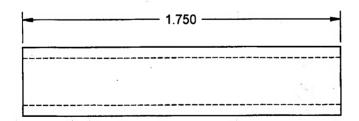
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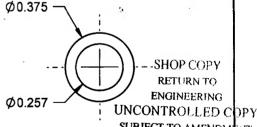
REV

DATE



D2327-1 SPACER BUSHING





D2327-3 SPACER BUSHING

SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 40390

NOTES

1) MATERIAL: AISI 304/316 SS, Ø0:375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)

 \wedge

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B				Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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